

Work Order ID 144915

April 27, 2016 3:14:03 PM

144915

Bill Order -

Page 1

Item ID: D412-704-015

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 4/28/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/10/2016 Req'd Qty: 1.00

1

Customer:

Reference:

~~U/R~~ 16.05.17.

Approvals: Process Plan: *SJA*

Date: **20160427**

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D412-704	D <i>U/R 16-577</i>								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D412-704-015 CHG002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.03							
Quality Control									

DAS
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9-89

MAY 13 2016

DAS
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9-89

MAY 08 2016

DAS
28
9-89

MAY 13 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐					

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Item ID: D412-704-015 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Co-Pilot's Emergency Cargo Release
 Start Date: 4/28/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/10/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-704-015 Location: _____ PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							
Quality Control									

MAY 13 2016
 DAS
 28
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MAY 17 2016
 MJS

MAY 17 2016
 MJS

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

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Work Order ID: 144915

144915

Parent Item: D412-704-015

D412-704-015

Parent Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 4/28/2016

Required Date: 5/10/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 12-03-22 JLM VERIFIED BY:EC IPP
REV:B 12.04.20 per cen-566 DD verf:EC IPP REV:C
12.05.10 per ECN 12-583 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-704-141		Manufactured	No			110	Each	0.0000	1	1			
D412-704-141									**	144916			DAS 27 9-89
Pedal Assembly	28 9-89												
D412-704-045		Manufactured	No			110	Each	4.0000	1	1			
D412-704-045									**				DAS 27 9-89
Cable Ass'y													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST215	4							
					144248	4							
D3207-5		Manufactured	No			110	Each	9.0000	1	1			
D3207-5									**				DAS 27 9-89
Bracket													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST024	9							
					116991	9							
D3207-7		Manufactured	No			110	Each	8.0000	1	1			
D3207-7									**				DAS 27 9-89
Packer													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST024	8							
					110077	8							

D3206-3 x1B 146154 MF 16-5-12

146154

16.05.17

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Work Order ID: 144915

144915

Parent Item: D412-704-015

D412-704-015

Parent Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 4/28/2016

Required Date: 5/10/2016

Start Qty: 1.00

Required Qty: 1.00

D3208-9 Manufactured No 110 Each 14.0000 1 1

D3208-9

Doubler

DAS

627

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST025

14

142241

14

D3214-1

Manufactured No

110 Each

17.0000

1

1

D3214-1

Decal

DAS

27

DAS-89

6

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST026

17

141572

17

D4610-1

Manufactured No

110 Each

10.0000

1

1

D4610-1

Doubler

DAS

6

DAS 27

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST112

10

119696

10

D4610-3

Manufactured No

110 Each

19.0000

1

1

D4610-3

Doubler

DAS

6

DAS 27

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST112

19

142233

19

D4610-7

Manufactured No

110 Each

23.0000

1

1

D4610-7

Cover

DAS

6

DAS 27

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST112

23

142239

23

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Work Order ID: 144915

144915

Parent Item: D412-704-015

D412-704-015

Parent Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 4/28/2016

Required Date: 5/10/2016

Start Qty: 1.00

Required Qty: 1.00

MS21919-DG5

Purchased No

110 Each

24.0000

4 4

MS21919-DG5

Clamp

DAS
28
9-89

Location

Loc Qty

Loc Code

ST293

24

m134134

24

D4622-1

Manufactured No

110 Each

6.0000

1 1

D4622-1

Placard

DAS
28
9-89

Location

Loc Qty

Loc Code

st113

6

132587

6

D4622-3

Manufactured No

110 Each

8.0000

1 1

D4622-3

Placard

DAS
28
9-89

Location

Loc Qty

Loc Code

st113

8

132697

8

MS35489-149

Purchased No

110 Each

88.0000

1 1

MS35489-149

GROMMET

DAS
28
9-89

Location

Loc Qty

Loc Code

ST269

88

121692

88

DAS
27
9-89

DAS
27
9-89

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27
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5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -041	Qty -141	Qty -043	Qty -045	Part Number	Description
X							D412-704-011	COPILOT'S EMERGENCY CARGO RELEASE KIT (210/212/214)
	X						D205-704-013	COPILOT'S EMERGENCY CARGO RELEASE KIT (205)
		X					D412-704-015	COPILOT'S EMERGENCY CARGO RELEASE KIT (412)
1	1		X				D412-704-041	PEDAL ASSEMBLY (205/210/212/214)
		1		X			D412-704-141	PEDAL ASSEMBLY (412)
	1				X		D205-704-043	CABLE ASSEMBLY (205)
1		1				X	D412-704-045	CABLE ASSEMBLY (210/212/214/412)
			1	1			D3204-041	PEDAL ASSEMBLY (OR ECM 999702-1)
			1	1			D3205-1	PEDAL BRACKET (OR ECM 999703-1)
			1	1			D3205-3	BACK PLATE (OR ECM 999709-5)
			1	1			D3206-1	PEDAL ARM (OR ECM 999704-1)
	1						D3207-1	BRACKET
	1						D3207-3	BRACKET
1		1					D3207-5	BRACKET
1	1	1					D3207-7	PACKER
		1					D3207-9	BRACKET
1							D3207-11	BRACKET
1	1	1					D3208-1	DOUBLER (OR ECM 999709-1)
1	1	1					D3208-3	PEDAL MOUNT ANGLE (OR ECM 999709-7)
	1						D3208-5	MOUNT ANGLE
1	1	1					D3208-7	FILLER (OR ECM 999709-3)
1		1					D3208-9	DOUBLER
1		1					D3208-11	FILLER
			1	1			D3209-041	BRACKET ASSEMBLY (OR BHT 204-070-993-001)
1	1	1					D3214-1	PLACARD (OR ECM 999712-1)
					1		D3217-1	CABLE
						1	D3217-3	CABLE
					1	1	D3257-1	FITTING
					1	1	D3258-1	ANGLE BRACKET
		1					D4610-1	DOUBLER
		1					D4610-3	DOUBLER
			1	1			D4610-5	SHIM
		1					D4610-7	COVER
				1			D4611-1	BUSHING
		1					D4622-1	PLACARD
		1					D4622-3	PLACARD
			1	1	1	1	AN3-10A	BOLT
			1	1			AN315-4R	NUT
					1	1	AN3-5A	BOLT
			2	2			AN3-6A	BOLT
			1	1			AN4-10A	BOLT
			2				AN4-11A	BOLT
				2			AN4-12A	BOLT
			1				AN4-13A	BOLT
				1			MS20002-4	WASHER

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Revision: **D**
Date: 14.12.02

Qty -011	Qty -013	Qty -015	Qty -041	Qty -141	Qty -043	Qty -045	Part Number	Description
				1			MS20004-24	BOLT
			3	3	2	2	MS21042L3	NUT (OR MS21042-3)
			5	5			MS21042L4	NUT (OR MS21042-4)
	4	4					MS21919DG5	CLAMP
			1				MS24694-S102	SCREW
				1			MS24694-S104	SCREW
	2						MS35489-10	GROMMET
		1					MS35489-149	GROMMET
			1	1			MS9519-10	BOLT
			4	4	2	2	NAS1149D0332J	WASHER (OR AN960JD10L)
			5	5	2	2	NAS1149D0363J	WASHER (OR AN960JD10)
			3	2			NAS1149D0416J	WASHER (OR AN960JD416L)
			14	13			NAS1149D0463J	WASHER (OR AN960JD416)
					3	3	NAS509-3	NUT

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Date: 14.12.02